

Date: Thursday, 1/17/2008 3:23:52 PM
 User: Kim Johnston

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT
 Job Number : 36811B
 Estimate Number : 10462
 P.O. Number :
 This Issue : 1/17/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D32782
 Drawing Number : D3278 REV. C
 Project Number : N/A
 First Issue : 1/1 Type : SMALL /MED FAB Drawing Revision : C
 Material :
 Previous Run : 36119B Due Date : 1/24/2008 Qty: 225 Um: Each
 Written By :
 Checked & Approved By : J08 0118
 Comment : Est.A 04.04.19 New issue KJ/JLM
 Est B 07.09.06 Rev C dwg EC Verified by: JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.2454 f(s)/Unit Total : 40.3062 f(s) 55.215 f

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
 (M6061T6B1.000x02.000)

Batch: M107129

C208/02/15 55.215

2.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

1.1 Issue No: 3055 C208/02/08 225
 C10BUS.

10/4/10
 80

12 Decrive and inspect for transit damage ensure a copy of cert attached

12 Page 1 of 1 08/03/11 400 counts

Form 1000000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:23:52 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 36811B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(80X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/03/11

7.0

POWDER COATING

POWDER COATING



M107005

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 08/03/11

(80)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(80X)

Comment: INSPECT POWDER COAT

M-1

08/03/12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 80

AS

08/03/13

(X80)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(80)

Comment: FINAL INSPECTION/W/O RELEASE

D08/03/14

Job Completion



mi 2008/3/13

(80)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 36811B
Description: Support		Part Number: D3278-2
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000					
0.359	+/-0.005					
0.609	+/-0.010					
0.250	+/-0.010					
1.480	+/-0.005					
R0.125	+/-0.010					
0.119	+0.005/-0.004					
2.439	+/-0.010					
1.980	+/-0.010					
R0.13	+/-0.030					
Ø0.257	+0.005/-0.000					
R0.375	+/-0.010					
0.875	+/-0.010					
0.500	+/-0.010					
R0.400	+/-0.010					
R1.00	+/-0.030					
1.720	+/-0.010					
R0.125	+/-0.010					
0.125	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

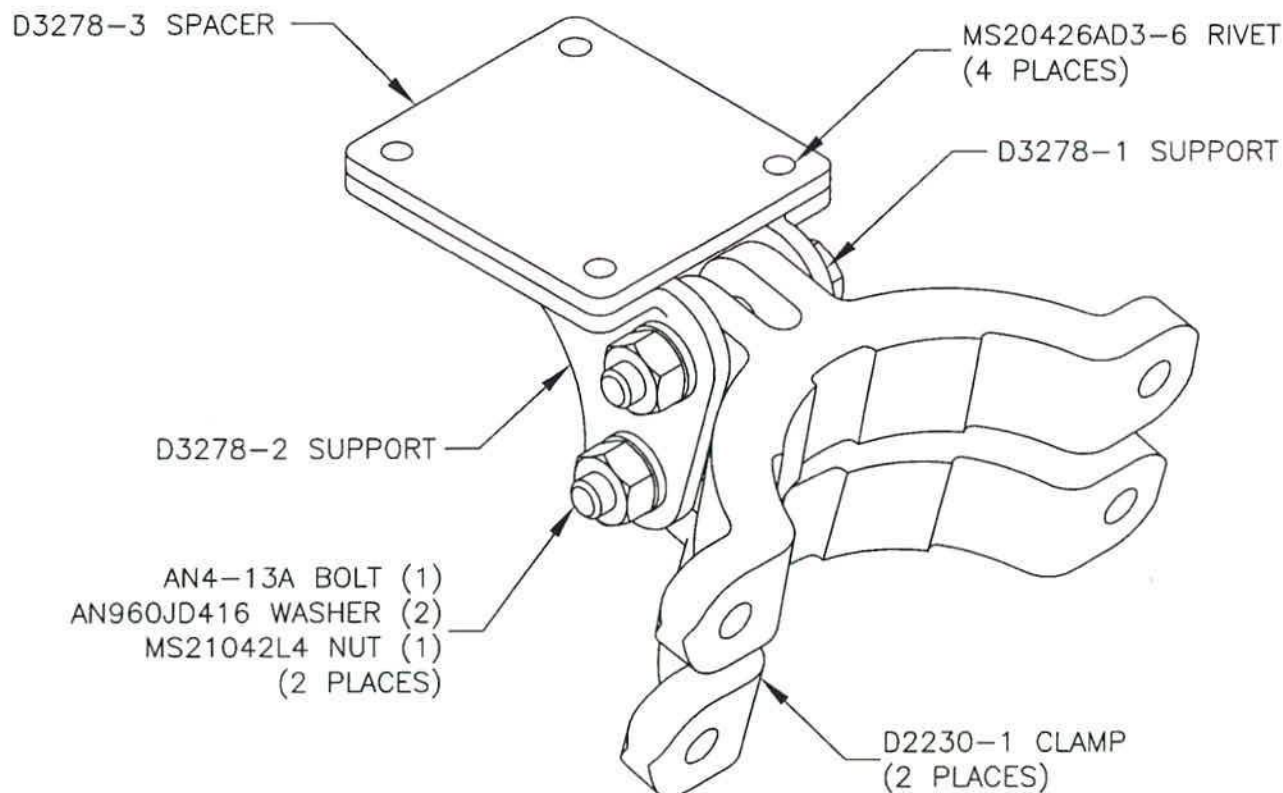
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	EE



DESIGN <i>92</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

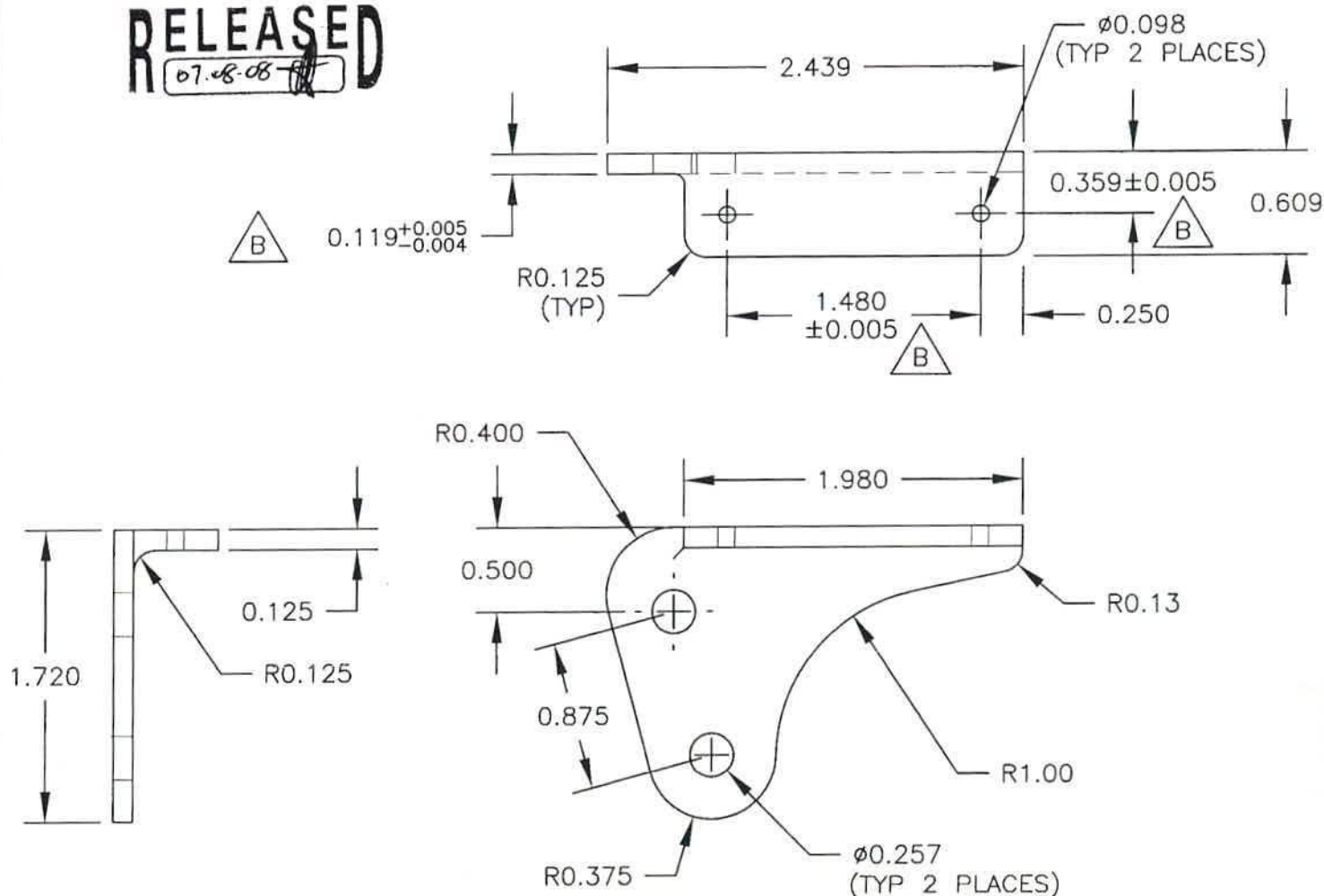
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DESIGN 9P	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

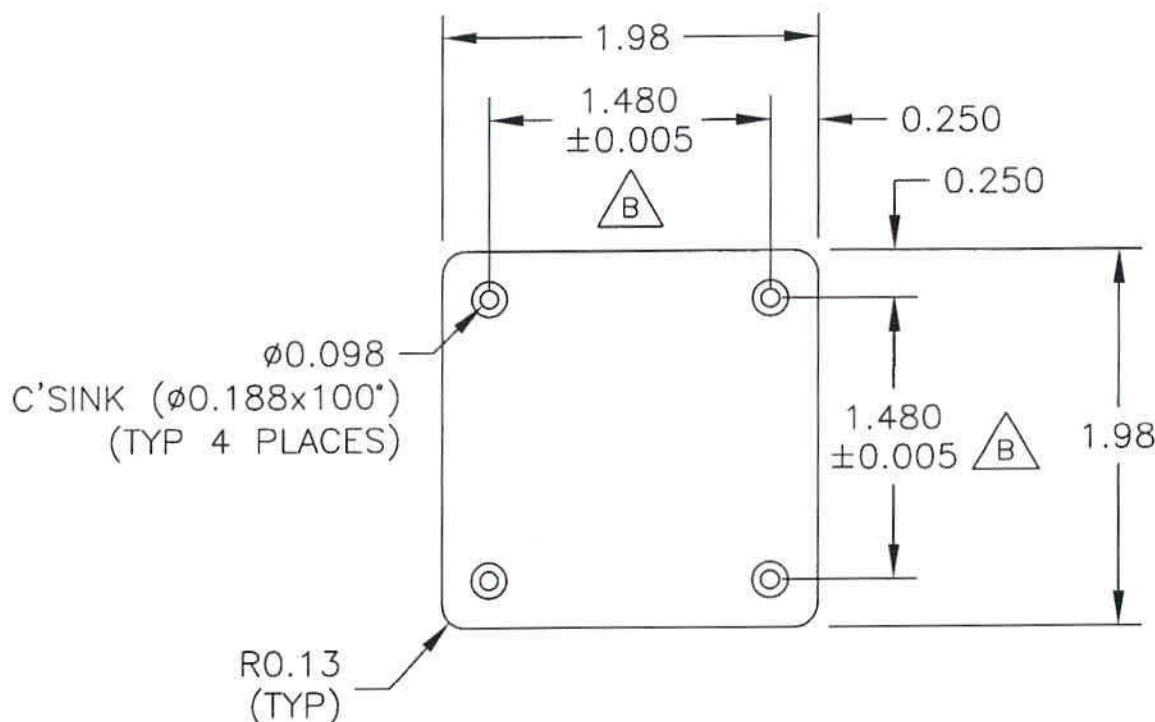
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DART

DESIGN 9P1	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
3/7/2008	16997

BILL TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

SHIP TO
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
000005655	Net 30	3/7/2008	Pick-Up	632	Globus

QTY	DESCRIPTION	RATE	AMOUNT
113	D3278-1 Rev.C Support → 112	7.63	862.19T
1	Machine Setup	75.00	75.00T
80	D3278-2 Rev.C Support ✓	7.63	610.40T
1	Machine Setup	75.00	75.00T
1	NRE-Programming	50.00	50.00T
Business Number: 102122058			
<p>ALL PARTS HAVE BEEN MANUFACTURED TO DRAWINGS AND PURCHASE ORDER SPECIFICATIONS</p>			

GST	83.63
PST	0.00

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

TOTAL \$1,756.22

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts